

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006577**Date Inspected:** 03-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Le and Zhang Zhi Weng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA inspector performed MT of approximately 15% and VT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as Lift 3 South Tower Skin B. The weld designations reviewed are as follows:

Bay 10

1. Welds between skin plate and stiffener B2.

Bay 11

FCAW welding of weld joint 74 located on PCMK WD1-A25A/E.

Welder is identified as Mr. Liu Jingyong (067500). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

FCAW welding of weld joint 73 located on PCMK WD1-A25A/E.

Welder is identified as Mr. Li Shoufu (066674). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-P5.

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FCAW welding of weld joint 55 and 56 located on ESD1-TL7K/L.

Welder is identified as Mr. Shi Jiabao (068494). ZPMC QC is identified as Mr. Zhang Zhi Weng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P6-F.

FCAW welding of weld joint 57 and 58 located on ESD1-TL7J/L.

Welder is identified as Mr. Zhang Xinmin (066484). ZPMC QC is identified as Mr. Zhang Zhi Weng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P6-F.

FCAW welding of weld joint 55 and 56 located on ESD1-TL7K/L.

Welder is identified as Mr. Zhang Lliang (067036). ZPMC QC is identified as Mr. Zhang Zhi Weng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P6-F.

FCAW welding of weld joint 57 and 58 located on ESD1-TL7J/L.

Welder is identified as Mr. Xiao Ayong (070022). ZPMC QC is identified as Mr. Zhang Zhi Weng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P6-F.

FCAW welding of weld joint 4B located on WSD1-FASA3-2E/E.

Welder is identified as Mr. Zhao Guiting (040723). ZPMC QC is identified as Mr. Li Lei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

Bay 10

FCAW welding of weld joint 112 located on NSD1-A116E/J.

Welder is identified as Mr. Wang Kui (203977). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joint 62~65 and 68~71 located on NSD1-A112F/H.

Welder is identified as Mr. Dong Yuqin (053116). ZPMC QC is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

Bay 13

SAW welding of weld joint 009 located on SEG046A.

Welder is identified as Mr. Wang Min (044771). ZPMC QC is identified as Mr. Lu Li Qing.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

Outside Machining

This QA inspector observed machining of base end of the South Tower Lift 1 was in progress on this work shift.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Alaniz,Joe     | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Carreon,Albert | QA Reviewer                 |

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